Work Order ID 113558 Monday, February 24, 2014 8:44:17 AM		*113	3558*		_	Ship	100	lay	Page 1	
tem ID: D3646-3 Revision ID: tem Name: Arm		Accept	*N900	<u>040</u>	100	7* s	Setup Sta	171	S1* S2*	
Start Date: 2/24/2014 Start Qty: 1.00 Required Date: 2/24/2014 Req'd Qty: 1.00 Reference:	*1* *1*		Cust Item I Customer:	D :				IV		
Approvals: Process Plan: M. QC:	Date: 4-2-24 Date:	Tooling: _ SPC (Y/N):		ate:		R	tun Sta Sto	• • • • • • • • • • • • • • • • • • •	R1* R2*	
Sequence ID/ Operation Work Center ID Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr Revision Nbr								•		
D3646 Rev C										
*1 NC BRAKE Brake NC Brake NC Memo 1-Punch to I	length as per Dwg D3646 &	0.00 0.00 template DT8959							14-02-	-2 Y
.10 *110* Small Fab Small Fab Memo Gmall Fab 1-Deburr2-	Bend as per dwg D3646	0.00			e de la companya de l				FF 14-02	-24
QC5- Inspect part complete A 1 20* QC Memo Quality Control	leteness to step on W/O	0.00 PAS 27 0.00 1427	Y							

DQA:			Date:											
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QA Closeu.			Date.								•	, ,		
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT,	PROCESS		
	-				_	Rework			Skid-tube	Crosstube]	Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	\sqcap	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR N	No.	1 				Suspected Unapproved			Large Fab	Composite	j	Supplier		
Root	T			1	Desci	ription of work order update		nitial	Actio	on	Sign &		一	
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	—	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			Part Incorred		-	Temperature/Cure
	↤	Crimp/Kii	nk/Ripple	/Wave	<u> </u>	Burrs	L	1	ion Incomplete/Un		Part Lost/Mi	ssing	\vdash	Weld
	Ш	Cuffs				Contamination	<u> </u>	-₹	tions Incomplete/U	nclear	Part Moved		Ш	Wrong Stock Pulled
		Crushing			<u> </u>	Countersink	_	4	gned/off center	<u></u>	Positioned V			
	\vdash	Heat Trea			<u> </u>	Cut Too Short		Mislabe		<u></u>	Power Loss/	Surge		Other
	-	Inspectio	•	Tube	<u> </u>	Drawing	L	Misrea						
	\bigsqcup	Marks/Ch			<u> </u>	Drill Holes	_	Off-set				· · ·		
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		Wave/Tw	ist in Tub	oe e		Fit/Function	I	Out of	Sequence					

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Work Orde Monday, Februa				*113	558*							Page 2
Revision ID:	D3646-3 Arm			Accept	*N900	040	100)*	Setup	Start Stop	*N: *N:	S1* S2*
Start Date: Required Date: Reference:	2/24/2014 2/24/2014	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	ID:					, , ,	
Approvals:	Process Pla	n:í	Date:	Tooling:	D	ate:	-		Run	Start	*NI	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*NI	R2*
Sequence ID/ Work Center II)	Operation Description	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej		Reject Number	Insp. Stamp
120 Powder Coating		Black Sandtex(Ref:4.3.5.7 Memo START TIME	11-2	0.00 0.00 _OVEN.TEMPERATURE:					\$	* <i> </i> 4	1-2-9	94 88 88 88
140		QC3- Inspect Part Finish		0.00	DAS 27			1				
140 ^{QC}		Memo		0.00	2/34							

150

Identify as per dwg & Stock Location: 0.00

150

Quality Control

Packaging Memo

ship

0.00

14/2/24 (0)

Packaging

PQA:		Date:										"DART
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	date only	AEROSPACE
					DISPOSITION			AGAINS	r DE	PARTMENT	/PROCESS	1
Work Orde	r:					.		Adalito	. DE	,		, _
Part N	0				Rework Scrap Use-as-is			Skid-tube Crosstube Machining Small Fab noforming Finishing		4	Water Jet d. Eng. Coor re/Packaging	Engineering Quality Other
NCR N	lo				Suspected Unapproved		mem	Large Fab Composite	_	nec/stol	Supplier	
Root				Desci	ription of work order update	_	nitial	Action		Sign &	,	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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}	Cracks	- I. /p: I.		-	Broken/Damage/Defect	<u> </u>	Hardwa		\vdash	Part Incorred	 	Temperature/Cure
1	Crimp/Kir	пк/кірріє	e/wave	-	Burrs	<u> </u>	4	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination	\vdash	4	tions Incomplete/Unclear	\vdash	Part Moved		Wrong Stock Pulled
	Crushing			-	Countersink Cut Too Short	-	Mislabe	gned/off center	\vdash	Positioned V Power Loss/	_	Other
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Work Ord Monday, Febru				*113	3558*							Page 3
Item ID: Revision ID: Item Name:	D3646-3 Arm			Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	171	S1* S2*
Start Date: Required Date:	2/24/2014	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:	_		Run	Start Stop	*N	R1*
Sequence ID/ Work Center II	4.00	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		A I VI Reject Number	R2* Insp. Stamp
1 AO QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00					ع دع	<u>-</u> /‹		-26 f W-2-2

DQA:			Date:										`	r q λa^{2}
						WORK ORDER NON	-CC	ONFO	RMANCE / UF	PDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	•					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR I	No.					Suspected Unapproved]		Large Fab	Composite]	Supplier		
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		Centre N	ot Concer	ntric		BOM/Route	L	Grain			Over/Under	tolerance	s	et-up
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	લ [⊤	emperature/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	<u> </u> у	Veld
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		Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	C	ther
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Cl	natter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence					

14-02-24

' Monday, February 24, 2014 8:44:16 AM

Work Order ID: 113558

113558

Parent Item:

D3646-3

D3646-3

Parent Item Name: Arm

Start Date: 2/24/2014

Required Date: 2/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments:

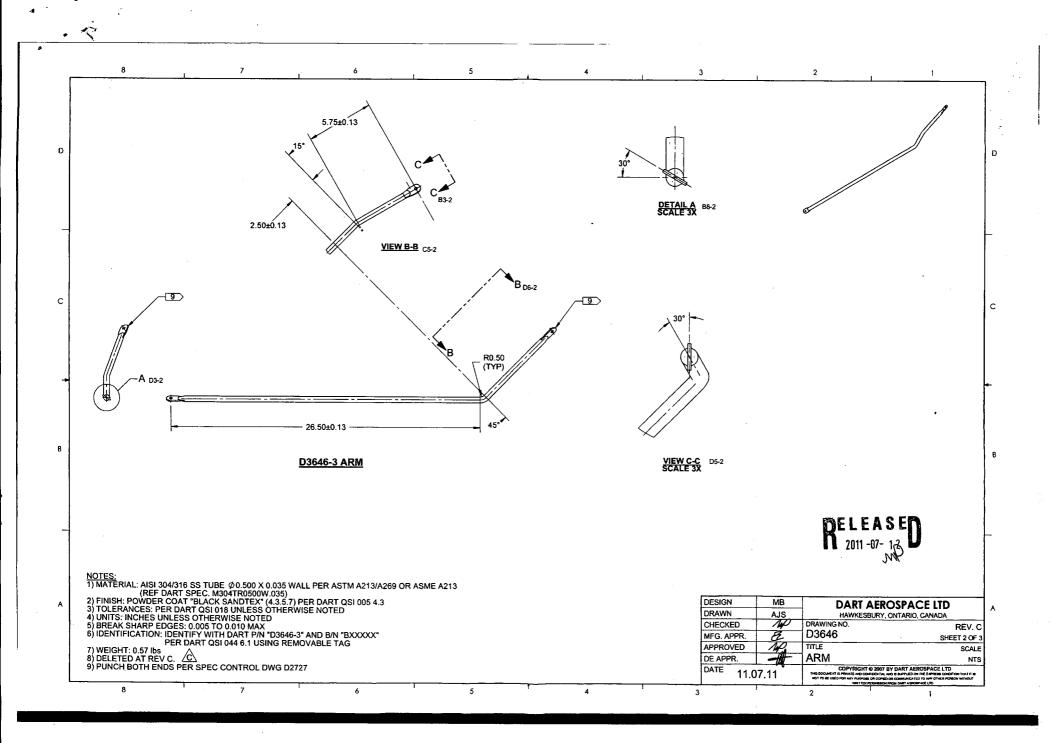
IPP Rev. A new issue 07.07.25 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No		110	f	219.1999	2.91	4			
*M304TR	0.500W	035 *						**		££		22 2

M304TR0 500W 035
304 RD Tube .500 x .035W

Location	Loc Qty	Loc Code	
MAT017	219.1999		W-2-112
125513	16.1999		
m126922	3		
m128084	200		<u> </u>

DQA:		Date:												
					WORK ORDER NON	-CC	ONFO	RMANCE / UP	DATE			_		AEROSPACE
QA Closed:		Date:								Wor	k Order up	date only		
Work Order:					DISPOSITION				AGAINST	DEP	ARTMENT/	PROCESS		
					Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part No.					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
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	Crushing				Countersink		4	gned/off center	TICICAL	─ ─	Positioned V	L Vrong		TOTAL STOCK I WILLIAM
<u> </u>	Heat Trea			\vdash	Cut Too Short	\vdash	Mislabe			\blacksquare	Power Loss/			Other
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	Wave/Tw				Fit/Function		4	Sequence		-				



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				•		DISPOSITION		·		AGAINS	-	PARTMENT			· · · · · · · · · · · · · · · · · · ·	•
Work Orde	er: _					DISF 03111014				AGAII43			PROCESS			
						Rework			Skid-tube	Crosstub			Water Jet		Engineering	
Part N	۱٥		,			Scrap			Machining	Small Fa	-	1	d. Eng. Coor.	_	Quality	
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		Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ાં		Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave		Burrs		inspect	ion Incomplete/	Unqualified	-	Part Lost/Mi	ssing		Weld	
		Cuffs				Contamination		Instruct	tions Incomplete	e/Unclear		Part Moved			Wrong Stock Pulled	
		Crushing				Countersink]Misalig	gned/off center	r		Positioned V				
		Heat Trea	at			Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other	
		Inspectio	n Strip in	Tube		Drawing		Misread	d							
÷		Marks/Ch	atter			Drill Holes		Off-set								
·		Turning S	equence			Finish		Out of	Calibration	•						
		\\/\2\\@/T\\	ist in Tub	۵۵		Fit/Eunction	Г	Tout of	Saguence							

DART AEROSPACE LTD



Part Number: \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	Description: ARM		Work Order:	113560
Inspection Drawing: 5.5645 Rev. C Fait Number: 12.5646	Inspection Drawing: >3646	Rev: C	Part Number:	D3646-3

INSPECTION SHEET

					JIILL		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method	of Inspection	Comments
26,50 45°	± 0.13	26.50		<u> </u>	SFa	15	
45°	1°	45° 15° 30°	V		1	15_	
150	10	150	V		((10 05	
7 7 7	10	30°	V		` '	05	
30"	10	305	V		1 \	05	
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2.50	±0,13	2.50	V		1 4	0/7_	
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Measured by:	Checked By: 30 9-89	QC inspector: PAS 27 9-89	Engineering Approval (if necessary):
Date 14-02-24	Date 14/02/24	Date MR/DY	Date
19-02 29	19100121		